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DAS  
21  
9-88

20NR-119-4

Job Sheet 191239



W/ 190799

Part No: 20NR-119-4

Job Qty: 8 pcs

Part Name: Left Top Feeder



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/25/19

Job Tracking No:

Due Date: 5/10/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG 20NR-119-4 Rev. 3 IPP Rev. A 18.08.08 new issue DP Verify DD

Ship Via:

## Bill of Materials

## Job Routing

| Op No | Operation           | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off    |
|-------|---------------------|-------|------------|----------|-----------|---------|-----------------------|-----------|-------------|
|       |                     |       |            |          | Setup Hrs | Run Hrs | Workcenter / Supplier | Lead Time |             |
| 100   | Waterjet - Omax - 1 | 8 pcs | 5/10/19    | 5/10/19  | 0.00      | 0.67    | Waterjet - Omax       |           | pc 19/04/01 |
| 110   | QC 2                | 8 pcs | 5/10/19    | 5/10/19  | 0.00      | 0.00    | QC 2 - 1              |           |             |
|       |                     |       |            |          |           |         | QC 2 - 12             |           |             |
|       |                     |       |            |          |           |         | QC 2 - 14             |           |             |
|       |                     |       |            |          |           |         | QC 2 - 17             |           |             |
|       |                     |       |            |          |           |         | QC 2 - 19             |           |             |
|       |                     |       |            |          |           |         | QC 2 - 2              |           |             |
|       |                     |       |            |          |           |         | QC 2 - 20             |           |             |
|       |                     |       |            |          |           |         | QC 2 - 22             |           |             |
|       |                     |       |            |          |           |         | QC 2 - 23             |           |             |
|       |                     |       |            |          |           |         | QC 2 - 25             |           |             |
|       |                     |       |            |          |           |         | QC 2 - 32             |           |             |
|       |                     |       |            |          |           |         | QC 2 - 33             |           |             |
|       |                     |       |            |          |           |         | QC 2 - 35             |           |             |
|       |                     |       |            |          |           |         | QC 2 - 39             |           |             |
|       |                     |       |            |          |           |         | QC 2 - 4              |           |             |
|       |                     |       |            |          |           |         | QC 2 - 40             |           |             |
|       |                     |       |            |          |           |         | QC 2 - 44             |           |             |
|       |                     |       |            |          |           |         | QC 2 - 45             |           |             |
|       |                     |       |            |          |           |         | QC 2 - 48             |           | pc 19/04/01 |
|       |                     |       |            |          |           |         | QC 2 - 49             |           |             |
|       |                     |       |            |          |           |         | QC 2 - 50             |           |             |
|       |                     |       |            |          |           |         | QC 2 - 51             |           |             |
|       |                     |       |            |          |           |         | QC 2 - 52             |           |             |
|       |                     |       |            |          |           |         | QC 2 - 54             |           |             |
|       |                     |       |            |          |           |         | QC 2 - 56             |           |             |
|       |                     |       |            |          |           |         | QC 2 - 57             |           |             |
|       |                     |       |            |          |           |         | QC 2 - 62             |           |             |
|       |                     |       |            |          |           |         | QC 2 - 63             |           |             |
|       |                     |       |            |          |           |         | QC 2 - 8              |           |             |
|       |                     |       |            |          |           |         | QC 2 - 66             |           |             |

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|     |                             |       |         |           |                             |
|-----|-----------------------------|-------|---------|-----------|-----------------------------|
|     |                             |       |         | QC 2 - 64 |                             |
| 120 | Conventional Mill - 1 - B4B | 8 pcs | 5/10/19 | 0.00 1.00 | Conventional Mill - 1 - B4B |
|     |                             |       |         |           | Conventional Mill - 2 - B4B |
| 130 | QC 2                        | 8 pcs | 5/10/19 | 0.00 0.00 | QC 2 - 1                    |
|     |                             |       |         |           | QC 2 - 12                   |
|     |                             |       |         |           | QC 2 - 14                   |
|     |                             |       |         |           | QC 2 - 17                   |
|     |                             |       |         |           | QC 2 - 19                   |
|     |                             |       |         |           | QC 2 - 2                    |
|     |                             |       |         |           | QC 2 - 20                   |
|     |                             |       |         |           | QC 2 - 22                   |
|     |                             |       |         |           | QC 2 - 23                   |
|     |                             |       |         |           | QC 2 - 25                   |
|     |                             |       |         |           | QC 2 - 32                   |
|     |                             |       |         |           | QC 2 - 33                   |
|     |                             |       |         |           | QC 2 - 35                   |
|     |                             |       |         |           | QC 2 - 39                   |
|     |                             |       |         |           | QC 2 - 4                    |
|     |                             |       |         |           | QC 2 - 40                   |
|     |                             |       |         |           | QC 2 - 44                   |
|     |                             |       |         |           | QC 2 - 45                   |
|     |                             |       |         |           | QC 2 - 48                   |
|     |                             |       |         |           | QC 2 - 49                   |
|     |                             |       |         |           | QC 2 - 50                   |
|     |                             |       |         |           | QC 2 - 51                   |
|     |                             |       |         |           | QC 2 - 52                   |
|     |                             |       |         |           | QC 2 - 54                   |
|     |                             |       |         |           | QC 2 - 56                   |
|     |                             |       |         |           | QC 2 - 57                   |
|     |                             |       |         |           | QC 2 - 62                   |
|     |                             |       |         |           | QC 2 - 63                   |
|     |                             |       |         |           | QC 2 - 8                    |
|     |                             |       |         |           | QC 2 - 66                   |
|     |                             |       |         |           | QC 2 - 64                   |
| 140 | QC 8                        | 8 pcs | 5/10/19 | 0.00 0.00 | QC 8 - 12                   |
|     |                             |       |         |           | QC 8 - 14                   |
|     |                             |       |         |           | QC 8 - 17                   |
|     |                             |       |         |           | QC 8 - 20                   |
|     |                             |       |         |           | QC 8 - 25                   |
|     |                             |       |         |           | QC 8 - 3                    |
|     |                             |       |         |           | QC 8 - 32                   |
|     |                             |       |         |           | QC 8 - 33                   |
|     |                             |       |         |           | QC 8 - 35                   |
|     |                             |       |         |           | QC 8 - 39                   |
|     |                             |       |         |           | QC 8 - 4                    |
|     |                             |       |         |           | QC 8 - 44                   |
|     |                             |       |         |           | QC 8 - 45                   |
|     |                             |       |         |           | QC 8 - 49                   |
|     |                             |       |         |           | QC 8 - 58                   |
|     |                             |       |         |           | QC 8 - 8                    |
|     |                             |       |         |           | QC 8 - 9                    |
|     |                             |       |         |           | QC 8 - 68                   |
|     |                             |       |         |           | QC 8 - 67                   |
|     |                             |       |         |           | QC 8 - 1 (A)                |
|     |                             |       |         |           | QC 8 - 47                   |
| 150 | Packaging 3-2 - Stock - B4B | 8 pcs | 5/10/19 | 0.00 0.00 | Packaging 3 - 1 - B4B       |
|     |                             |       |         |           | Packaging 3 - 2 - B4B       |
|     |                             |       |         |           | Packaging 3 - 3 - B4B       |
|     |                             |       |         |           | Packaging 3 - 4 - B4B       |



|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                |                     |                         | Packaging 3 - 5 - B4B  |             |
|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------|---------------------|-------------------------|------------------------|-------------|
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                |                     |                         | Packaging 3 - 6 - B4B  |             |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                |                     |                         | Packaging 3 - 7 - B4B  |             |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                |                     |                         | Packaging 3 - 8 - B4B  |             |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                |                     |                         | Packaging 3 - 9 - B4B  |             |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                |                     |                         | Packaging 3 - 10 - B4B |             |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                |                     |                         | Packaging 3 - 11 - B4B |             |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                |                     |                         | Packaging 3 - 12 - B4B | 2           |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                |                     |                         | Packaging 3 - 13 - B4B |             |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                |                     |                         | Packaging 3 - 14 - B4B |             |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                |                     |                         | Packaging 3 - 15 - B4B |             |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                |                     |                         | Packaging 3 - 16 - B4B |             |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                |                     |                         | Packaging 3 - 17 - B4B |             |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                |                     |                         | Packaging 3 - 18 - B4B |             |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                |                     |                         | Packaging 3 - 19 - B4B |             |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                |                     |                         | Packaging 3 - 20 - B4B |             |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                |                     |                         | Packaging 3 - 21 - B4B |             |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                |                     |                         | Packaging 3 - 22 - B4B |             |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                |                     |                         | Packaging 3 - 23 - B4B |             |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                |                     |                         | Packaging 3 - 24 - B4B |             |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                |                     |                         | Packaging 3 - 25 - B4B |             |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                |                     |                         | Packaging 3 - 26 - B4B |             |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                |                     |                         | Packaging 3 - 27 - B4B |             |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                |                     |                         | Packaging 3 - 28 - B4B |             |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                |                     |                         | Packaging 3 - 29 - B4B |             |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                |                     |                         | Packaging 3 - 30 - B4B |             |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                |                     |                         | Packaging 3 - 31 - B4B |             |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                |                     |                         | Packaging 3 - 32 - B4B |             |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                |                     |                         | Packaging 3 - 33 - B4B |             |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                |                     |                         | Packaging 3 - 34 - B4B |             |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                |                     |                         | Packaging 3 - 35 - B4B |             |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                |                     |                         | Packaging 3 - 36 - B4B | APR 09 2019 |
| 160 QC 21 - SA                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | 8 pcs          | 5/10/19             | 0.00 0.00               | QC 21 - SA - 21        |             |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                |                     |                         | QC 21 - SA - 70        |             |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                |                     |                         | QC 21 - SA - 53        | DAS 21 9-88 |
| Part Op <b>100</b> - 1-Cut as per Dwg Dwg Rev: <u>3</u> Prog Rev: <u>3</u> 2-Deburr if necessary<br>Descriptions: <b>110</b> - (QC2- Inspect parts off machine FAI/FAIB)<br><b>120</b> - (Manufacture as per dwg)Machine as per DWG.<br><b>130</b> - (QC2- Inspect parts off machine FAI/FAIB)<br><b>140</b> - (QC8- Inspect parts - second check)***NOTE***part to be bent at welding as per DWG.<br><b>150</b> - (Identify as per dwg & Stock Location: _____)IDENTIFY AND STOCK<br><b>160</b> - (QC21- Final Inspection - Work Order Release) |                |                     |                         |                        |             |
| <b>Job BOM</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                |                     |                         |                        |             |
| Part / Item                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      | Component Name | Quantity            | Operation               | Container              |             |
| M1018S.250<br>MT-HPS-P-1250                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      | M1018S.250     | 2.3600 sf (.295 ea) | 100-Waterjet - Omax - 1 | S165600                |             |
| <b>Job Allocations</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                |                     |                         |                        |             |
| Operation                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        | Component Part | Required            | Inventory               | Allocated              |             |
| 100-Waterjet - Omax - 1                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          | M1018S.250     | 2                   | 16                      | 0                      |             |
| <b>Part Specifications</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |                |                     |                         |                        |             |
| Specifications could not be found.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                |                     |                         |                        |             |

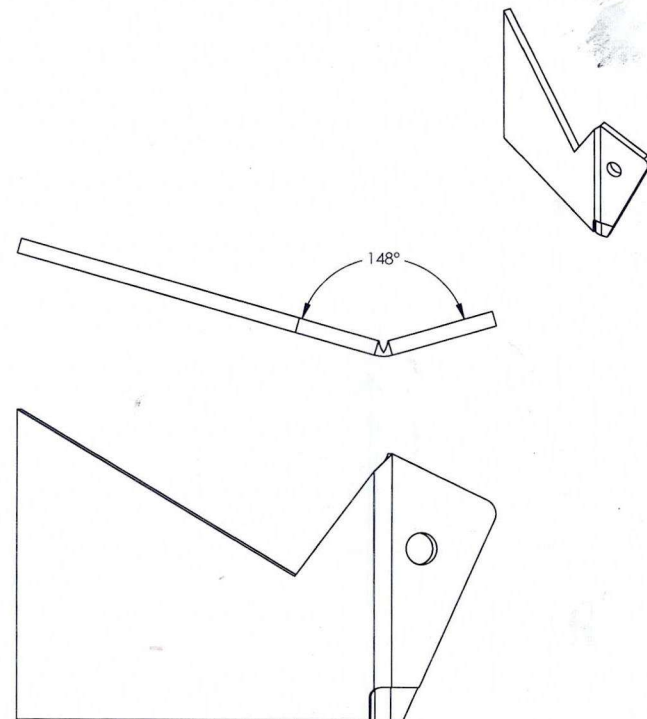
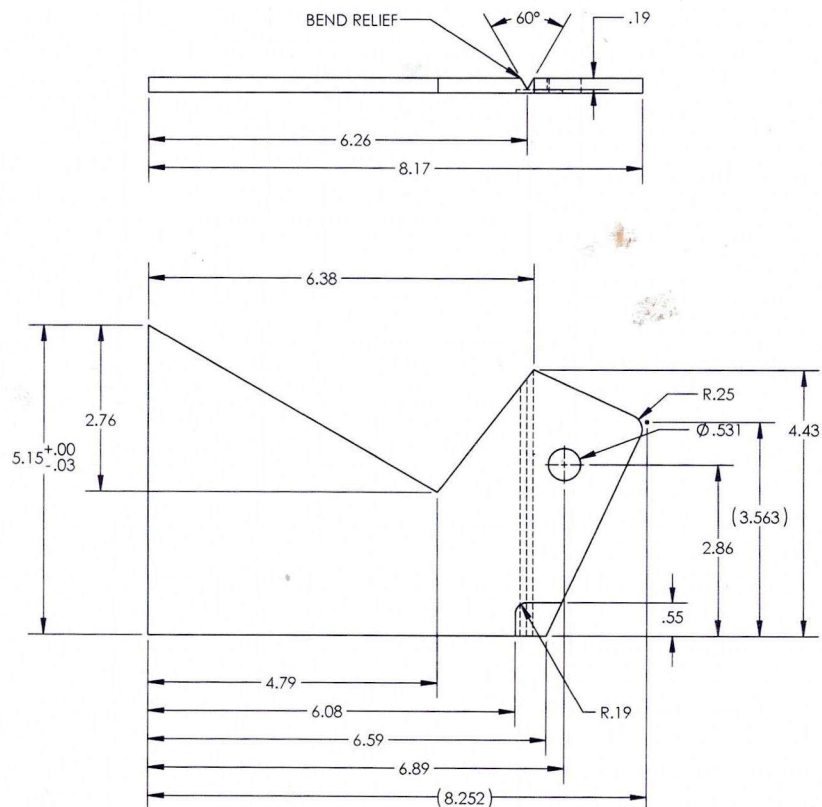
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| REVISIONS |                                            |           |         |          |
|-----------|--------------------------------------------|-----------|---------|----------|
| REV       | DESCRIPTION                                | DATE      | INITIAL | APPROVED |
| 2         | AS DRAWN BY CANAM                          | 7/22/2013 | CFS     |          |
| 3         | CH'D DIMENSION WAS 5.24 IS 5.15 +.00 -.03. | 6/18/2014 | DJN     | GE       |

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 191239405  
190225



BEND AT WELDMENT

| USED ON  |
|----------|
| 20NR-119 |
| 8NR-119  |
| 20NR-86  |
| 8NR-86   |

|                                                        |                         |
|--------------------------------------------------------|-------------------------|
| <b>RED BARN MACHINE</b>                                |                         |
| TITLE<br><b>LEFT TOP FEEDER</b>                        |                         |
| DWG NO.<br><b>20NR-119-4</b>                           | REV<br><b>3</b>         |
| MAT'L 1018                                             | DRAWN BY: CANAM         |
| UNLESS OTHERWISE SPECIFIED<br>DIMENSIONS ARE IN INCHES | APPROVED <i>D. Weil</i> |
| .XXX ± .005                                            | FRACTIONS ± 1/32        |
| .XX ± .01                                              | ANGLES ± 5°             |
| X ± .1                                                 | FINISH SEE WELDMENT     |
| 1. BREAK ALL SHARP EDGES .015 x 45°                    | SPEC                    |
| OR .015R                                               | USED ON MODEL           |
| 2. DIMENSIONAL LIMITS APPLY AFTER PLATING              |                         |
| SCALE 1:2                                              | DATE 12/1/1995          |
| SHEET 1 OF 1                                           |                         |

| ASSY QTY | ASSY QTY | B/O | Part #     | UNIT QTY | Description     | Material | B/O INFORMATION OR SPECIFICATIONS |
|----------|----------|-----|------------|----------|-----------------|----------|-----------------------------------|
|          |          |     | 20NR-119-4 | 1        | LEFT TOP FEEDER | 1018     | 1/4 X 5-3/8 X 8-3/8               |



Entered: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. \_\_\_\_\_

Route update only ☐

|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |                                                                                                                    |  |
|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|--------------------------------------------------------------------------------------------------------------------|--|
| Job: _____<br><br>Part No. _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/> | <b>DEPARTMENT/PROCESS</b><br><br><div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/><br/>           Machining <input type="checkbox"/><br/>           Large Fab <input type="checkbox"/> </div> <div>           Cross tube <input type="checkbox"/><br/>           Small Fab <input type="checkbox"/><br/>           Finishing <input type="checkbox"/> </div> <div>           Eng. (Non-AW) <input type="checkbox"/><br/>           Prod. Eng. Coord. <input type="checkbox"/><br/>           Rec/Store/Packaging <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/><br/>           Water Jet <input type="checkbox"/><br/>           Supplier <input type="checkbox"/><br/>           Quality <input type="checkbox"/> </div> </div>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |  |                                                                                                                    |  |
| Date :                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  | Sequence #:                                                                                                                       | QTY Affected :                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |  | <b>MRB (QS1042)</b><br><br>Completed By _____<br><br>Lead hand / Supervisor _____<br><br>QC / QA Coordinator _____ |  |
| Description Work Order Deviation                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                                                                                                                                   | Disposition                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |  |                                                                                                                    |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |                                                                                                                    |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |                                                                                                                    |  |
| <b>Root Cause</b><br><br><div style="display: flex; flex-direction: column;"> <div>Operator <input type="checkbox"/></div> <div>Manufacturing Process <input type="checkbox"/></div> <div>Equip/Tooling <input type="checkbox"/></div> <div>Handling/Presservation <input type="checkbox"/></div> <div>Material <input type="checkbox"/></div> <div>Product Improvement <input type="checkbox"/></div> <div>Process Improvement <input type="checkbox"/></div> <div>Human Factors <input type="checkbox"/></div> </div> |                                                                                                                                   | <b>FAULT CATEGORY</b><br><br><div style="display: flex; flex-wrap: wrap;"> <div style="width: 50%;"> <input type="checkbox"/> Pressure/Forced<br/> <input type="checkbox"/> Bending<br/> <input type="checkbox"/> Crushing<br/> <input type="checkbox"/> Cracks<br/> <input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist<br/> <input type="checkbox"/> Marks/Chatter<br/> <input type="checkbox"/> Mislabeled         </div> <div style="width: 50%;"> <input type="checkbox"/> Contamination<br/> <input type="checkbox"/> Misaligned/off center<br/> <input type="checkbox"/> BOM/Route<br/> <input type="checkbox"/> Broken/Damage/Defect<br/> <input type="checkbox"/> Incomplete/Unclear Instructions<br/> <input type="checkbox"/> Drill Holes<br/> <input type="checkbox"/> Fit/Function         </div> <div style="width: 50%;"> <input type="checkbox"/> Power Loss/Surge<br/> <input type="checkbox"/> Folio/Program<br/> <input type="checkbox"/> Grain Direction<br/> <input type="checkbox"/> Weld<br/> <input type="checkbox"/> Wrong Stock Pulled<br/> <input type="checkbox"/> Out of Sequence<br/> <input type="checkbox"/> Off-set/Set-up         </div> <div style="width: 50%;"> <input type="checkbox"/> Positioned Wrong<br/> <input type="checkbox"/> Outside Tolerance<br/> <input type="checkbox"/> Drawing<br/> <input type="checkbox"/> Finish<br/> <input type="checkbox"/> Part Lost/Missing<br/> <input type="checkbox"/> Misread         </div> </div> |  |                                                                                                                    |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                   | Other/Details:                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |  |                                                                                                                    |  |

# DART AEROSPACE

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Container No: S168401

Part: 20NR-119-4

Job No: 191239

Serial No/Batch: S168401

Revision: 3

Inspector:

Exp Date:

Instructions:

Date: 04/01/19